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IS : 11055 - 1984

Indian Standard
SPECIFICATION FOR
COTTON BLUE AIRMAIL BAGS

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TO
IS 11055 : 1984 SPECIFICATION FOR COTTON
BLUE AIRMAIL BAGS**

(*Page 5, Fig. 1*) — Substitute 'INDIA POST' for 'INDIAN POST OFFICE'.

(*Page 6, Fig. 2*) — Substitute 'INDIA POST' for 'INDIAN POST OFFICE'.

(TXD 20)

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Indian Standard

SPECIFICATION FOR COTTON BLUE AIRMAIL BAGS

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Indian Standard

SPECIFICATION FOR COTTON BLUE AIRMAIL BAGS

0. FOREWORD

0.1 This Indian Standard was adopted by the Indian Standards Institution on 15 March 1984, after the draft finalized by the Made-up Textile Items Sectional Committee had been approved by the Textile Division Council.

0.2 Various types of postal bags are being used by the Posts and Telegraphs Department. The basic cloth specification and constructional details of the bags varies depending on the end use. In order to cover various types of bags, the Made-up Textile Items Sectional Committee took the decision to make separate specification for each type in order to make it more illustrative and comprehensive. This standard supersedes IS : 5595-1970.

0.3 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS : 2-1960*. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

1. SCOPE

1.1 This standard prescribes constructional details and other requirements of airmail postal bags, made from cotton dosuti.

2. MANUFACTURE

2.1 The bags shall be manufactured from cotton dosuti (240 g/m²) conforming to IS : 179-1977† in all respects except for colour fastness which shall be according to 3.4 of this standard. The colour of the cloth shall be blue.

2.2 The bags shall be made from single piece of cloth, except AM I and AM II types.

*Rules for rounding off numerical values (*revised*).

†Specification for cotton dosuti (*second revision*).

2.2.1 Bag of AM I and AM II types shall be made out of 2 pieces one for the sides and the other forming the bottom. The bottom portion should be of a square shape measuring 35×35 cm, the around measurement being 140 cm (*see* Fig. 1).

2.3 Seam — The sides of the bag shall be machine stitched using two rows of stitches. The first turning-in of the cloth should be about 5 mm and the second turning-in of the cloth should be about 10 mm. The stitches shall be of even tension throughout with all the loose ends securely fastened. The number of stitches per decimetre shall be 28, *Min.* The seam should be on the inner side of the bag to prevent fraying.

2.4 Tabs — Tabs for fixing cast aluminium loops to the bags shall be of the same basic material as of the bags. The tabs shall be secured with double layer of cloth and neatly stitched on the bags at the mouth. They shall be of a dimension commensurate with the size of the bags (*see* Fig. 1 or Fig. 2).

2.5 Thread — The sewing thread used for stitching (*see* 2.3 and 2.4) shall conform to 36s/6 (165 dtex $\times$ 6) of IS : 1720-1978*. The colour and dye fastness of the sewing thread should be same as that of the basic material.

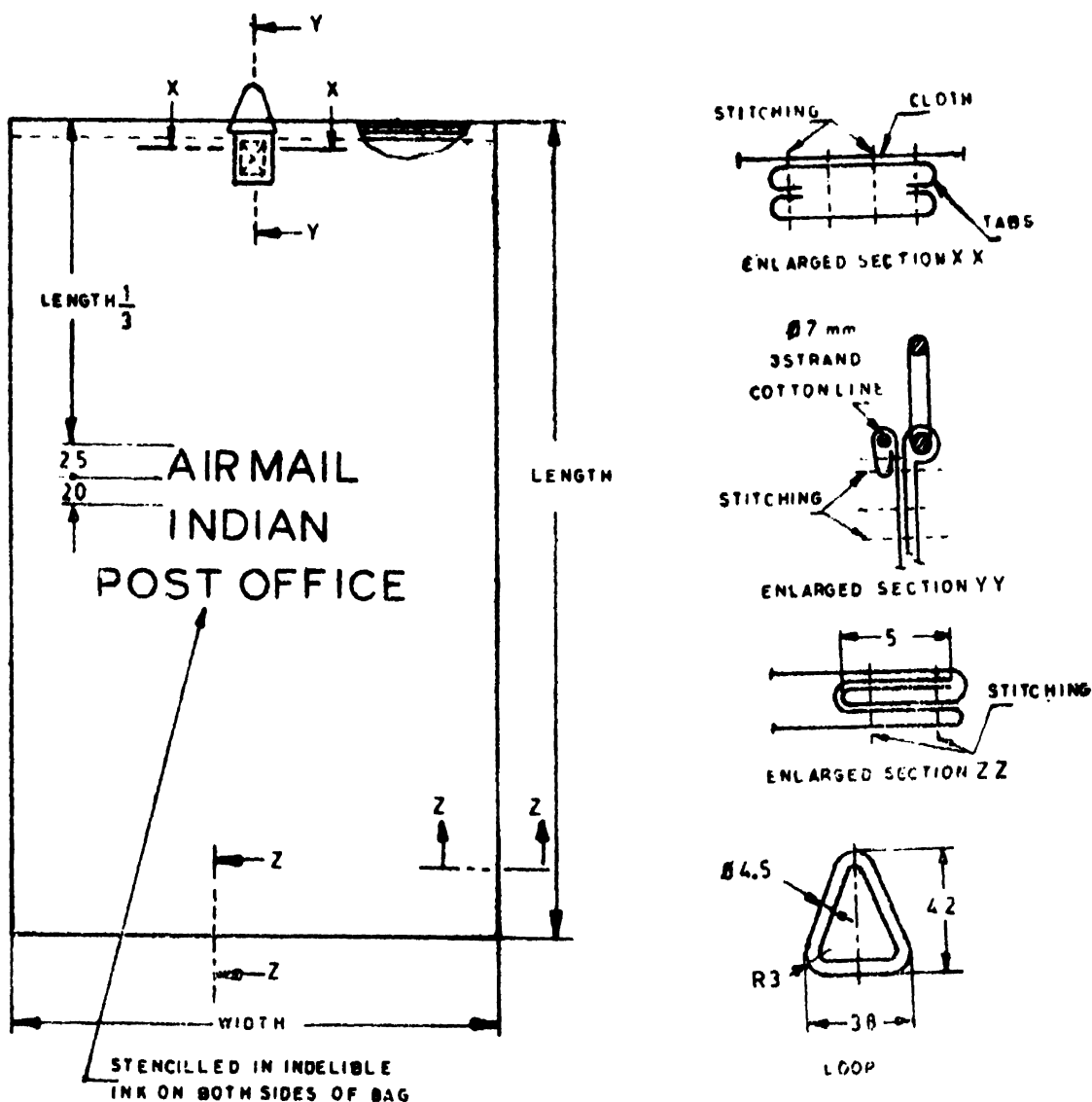
2.6 Loops — The cast aluminium loops shall not be finer than 4.5 mm in diameter. The approximate dimensions of the loops are shown in Fig. 1 or Fig. 2. Two or four loops, depending upon the size of the bag, shall be provided on each bag (*see also* Table 1).

TABLE 1 PARTICULARS OF COTTON BLUE AIRMAIL BAGS

(*Clauses 2.6, 2.8 and 3.2*)

SL No.	TYPE	SIZE OF BAG			SIZE (HEIGHT $\times$ THICKNESS OF LETTERS) FOR MARKING ON BAG	COLOUR OF INK TO BE USED FOR MARKING	No. OF LOOPS PER BAG
(1)	(2)	(3)			(4)	(5)	(6)
		cm	cm	cm	cm	cm	
i)	Airmail, AM I	105 $\times$ 35 $\times$ 35			5 $\times$ 1	Yellow	4
ii)	Airmail, AM II	75 $\times$ 35 $\times$ 35			5 $\times$ 1	Yellow	4
iii)	Airmail, AM III	50 $\times$ 35			2.5 $\times$ 0.6	Yellow	2

*Specification for cotton sewing threads (*second revision*).



All dimensions in millimetres.

FIG. 2 AIRMAIL BAG OF AM III TYPE

2.7 Mouth Reinforcing — The mouth of the bag shall be reinforced by providing a cotton line of 7 mm diameter securely stitched to it. The line shall be spliced to a length of 5 cm and whipped properly before being stitched with the body of the bag.

2.8 Marking on the Bag — The marking on the bags shall be as required by the postal department (see Table 1). It shall be done neatly using indelible ink (see IS : 394-1963*), on both sides of the bag. A typical positioning and size of the letter is shown in Fig. 1 or Fig. 2. Each bag shall also be marked, on the inner side, using indelible ink (see IS : 394-1963*), with the manufacturer's name or trade-mark; size, together with the year of manufacture.

*Specification for ink, cloth marking (revised).

2.8.1 Each bag may also be marked with the ISI Certification Mark.

NOTE — The use of the ISI Certification Mark is governed by the provisions of the Indian Standards Institution (Certification Marks) Act and the Rules and Regulations made thereunder. The ISI Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well-defined system of inspection, testing and quality control which is devised and supervised by ISI and operated by the producer. ISI marked products are also continuously checked by ISI for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the ISI Certification Mark may be granted to manufacturers or processors, may be obtained from the Indian Standards Institution.

2.9 Freedom from Defects — The bags should be free from sewing and other fabrication and basic fabric defects.

3. REQUIREMENTS

3.1 The general make up of the bag shall be as shown in Fig. 1 for AM I and AM II and Fig. 2 for AM III.

3.2 The size, type and other related details of the bags shall generally be as given in Table 1. A tolerance of ± 1 cm is allowed on size of bag.

3.3 If in order to illustrate or specify the indeterminable characteristics, such as workmanship, general appearance, lustre, feel and shade of the bag, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

3.3.1 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

3.4 Colour Fastness — The basic cloth shall be fast to light, washing and rubbing. The fastness rating shall be as given below when tested by the methods given against each:

<i>Fastness to</i>	<i>Rating</i>	<i>Method</i>
a) Light	4 or better	IS : 2454-1967* or IS : 686-1975†
b) Washing: Test 3	4 or better	IS : 764-1979‡
c) Rubbing	4 or better	IS : 766-1956§

*Method for determination of colour fastness of textile materials to artificial light (xenon lamp).

†Method for determination of colour fastness of textile materials to day light.

‡Method for determination of colour fastness of textile materials to washing: Test 3 (second revision).

§Method for determination of colour fastness of textile materials to rubbing.

4. PACKING

4.1 The bags shall be packed as agreed to between the buyer and the seller.

5. SAMPLING

5.1 Lot — The quantity of postal bags of same designation delivered to a buyer against a despatch note shall constitute a lot.

5.2 The conformity of the lot shall be determined on the basis of the tests carried out on the sample selected from it.

5.3 Unless otherwise agreed to between the buyer and the seller, the number of bags to be selected at random from a lot shall be according to col 1 and 2 of Table 2.

**TABLE 2 SAMPLE SIZE AND PERMISSIBLE NUMBER OF
NON-CONFORMING BAGS**

LOT SIZE	SAMPLE SIZE	PERMISSIBLE NO. OF NON-CONFORMING BAGS
(1)	(2)	(3)
Up to 100	13	1
101 to 150	20	2
151 to 300	32	3
301 to 500	50	5
501 to 1 000	80	7
1 001 to 3 000	125	10
3 001 and above	200	14

5.4 The number of bags selected according to 5.3 shall be examined for seam, tabs, aluminium loops, reinforcement of the mouth, marking, freedom from defects and the dimensions.

5.4.1 The number of bags to be examined for colour fastness shall be three for lot size less than 1 000 and five otherwise.

5.5 Criteria for Conformity — The lot shall be declared as conforming to the requirements of this specification if the following conditions are satisfied:

- a) The number of bags found not in conformity with the requirements for any one or more of the characteristics mentioned in 5.4 is less than or equal to the corresponding number given in col 3 of Table 2.
- b) All the test specimens tested for colour fastness are found satisfactory.



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